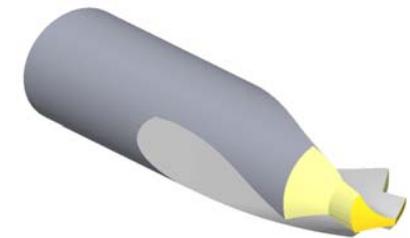


## Center Drill Ø10 Z2

A07-330

High speed grinding of Centerdrills: The below mentioned cycle considers a double sided center drill. If the flute is ground with conventional wheels (vitrified), then additional time for dressing has to be added for each 5 to 10 pieces. Dressing is also recommended when using CBN wheels, but only each 50 to 100 pieces.



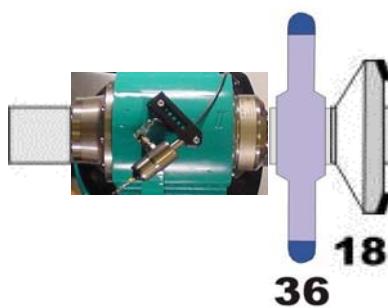
### 1. Cycletime for Production

Tool specifications							
Material HSS	Diameter 10 mm, Z 2, Length of cutting edge 15 mm, Helix angle 15°						
Operations	Flute	Step	End	Return	Flute	Step	End
Feed [mm/Min]	300	500	500	9000	300	500	500
Power [kW]	14	3	2	1	14	3	2
Cutting feed [m/s]	55	50	50		55	50	50
Used wheels							
Grinding time [s]	36	18	18		36	18	18
Total cycle time	2 Min 34						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

36	DXF Ø250_B126
18	12V2 Ø200-250



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR 26kW  
Control: Fanuc 31i  
Coolant: Synthetic Oil, pressure 18-26 bar  
Software: Quinto 5

responsible engineer: OP,31.10.08

[www.schneeberger.ch](http://www.schneeberger.ch)

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